

# Work Order ID 71127

Thursday, June 23, 2011 11:06:42 AM



Page 1

Item ID: D4039-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Bracket Assembly

Start Date: 6/23/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 7/6/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/06/23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D4039	B
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100

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble lanyard to bracket as per dwg

3X

12/06/19

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/12/06/19

(3)

120

Identify as per dwg & Stock Location: 167

0.00



Packaging

Memo

0.00

Packaging

12/06/20 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 71127**

Thursday, June 23, 2011 11:06:42 AM

Page 2

Item ID: D4039-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Bracket Assembly

Start Date: 6/23/2011 Start Qty: 3.00

Cust Item ID:

Required Date: 7/6/2011 Req'd Qty: 3.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

12/6/22 JF  
MLJ 12/06/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 23, 2011 11:06:39 AM

Page 1

Work Order ID: 71127

Parent Item: D4039-043

Parent Item Name: Aft Bracket Assembly



Start Date: 6/23/2011

Required Date: 7/6/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.12.15 verified by:EC  
B:AS PER ECN 10-563 10-09-28 JLM VERIFIED BY:DD

IPP REV

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4039-3 		Manufactured	No			100	Each	0.0000	1	3		6/12/06/19	
Aft Bracket													
D2690-6 		Manufactured	No			100	Each	46.0000	1	3		6/12/06/19	
Lanyard Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST020		46							
				66873		1							
				70920		45							
BLRS-010 		Purchased	No			100	Each	25.0000	1	3		6/12/06/19	
Pip Pin													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST283		25							
				116348		3							
				117784		12							
				117785		10							
MS27039-1-11 		Purchased	No			100	Each	66.0000	1	3		6/12/06/19	
Screw													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MEZZ		66							
				9662		66							

B 71152 (3x)

B 83360

M 121374 (3x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 23, 2011 11:06:39 AM

Page 2

Work Order ID: 71127



Parent Item: D4039-043



Parent Item Name: Aft Bracket Assembly

Start Date: 6/23/2011

Required Date: 7/6/2011

Start Qty: 3.00

Required Qty: 3.00

MS21042L3

Purchased

No

100

Each

2,025.000

1

3



Nut



*ES* 6/26/11  
M12/444  
(300)

Location

Loc Qty

Loc Code

ST300

2025

116549

325

117441

800

117601

400

117885

500

NAS1149D0363J

Purchased

No

100

Each

3,737.000

3

9



Washer



*ES* 6/26/11

Location

Loc Qty

Loc Code

ST298

3737

117291

737

117505

500

117601

500

118077

2000

M120644  
(900)

Thursday, June 23, 2011 11:06:39 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

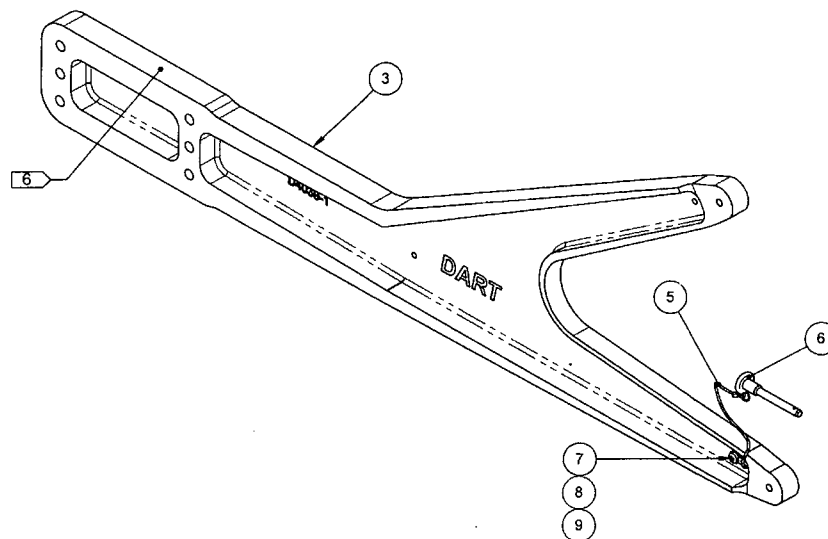
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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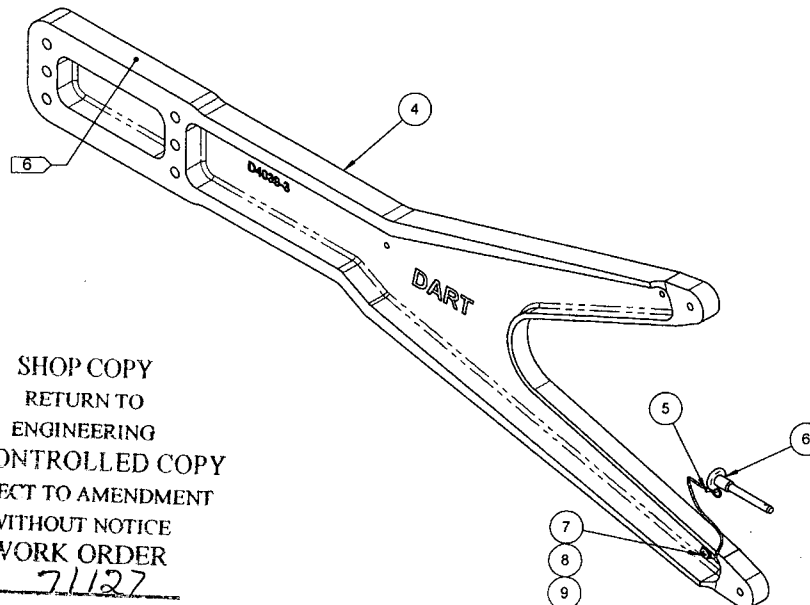


ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D4039-041	FWD BRACKET ASSEMBLY
2		X	D4039-043	AFT BRACKET ASSEMBLY
3	1		D4039-1	FWD BRACKET
4		1	D4039-3	AFT BRACKET
5	1	1	D2690-6	LANYARD
6	1	1	BLRS-010	PIP PIN
7	1	1	MS27039-1-11	SCREW
8	1	1	MS21042L3	NUT
9	3	3	NAS1149D0363J	WASHER



**D4039-041 FWD BRACKET ASSEMBLY**

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: N/A

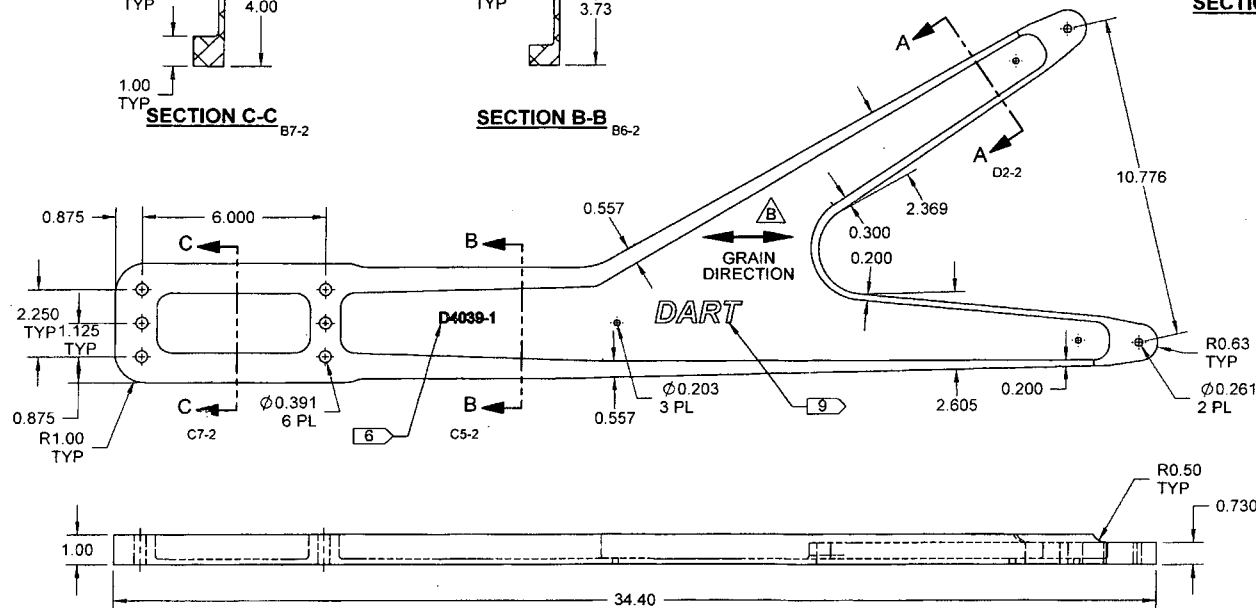
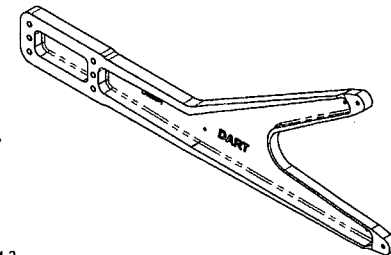
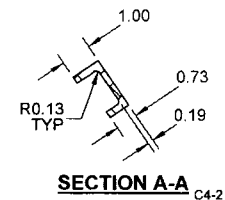
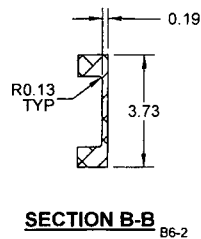
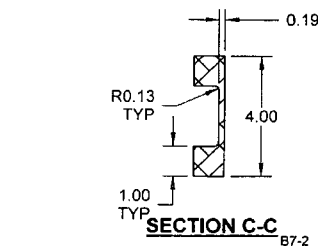


**D4039-043 AFT BRACKET ASSEMBLY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71127  
*CX11/06/23*

**RELEASED**  
2010-09-27

B	REVISE HOLE SIZE ON D4039-3 FROM 0.191 TO 0.203, ZN B6-3	HS	10.04.28
A	NEW ISSUE	HS	09.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.28		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4039</b> TITLE <b>BRACKET</b> REV. B SHEET 1 OF 3 SCALE NTS <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

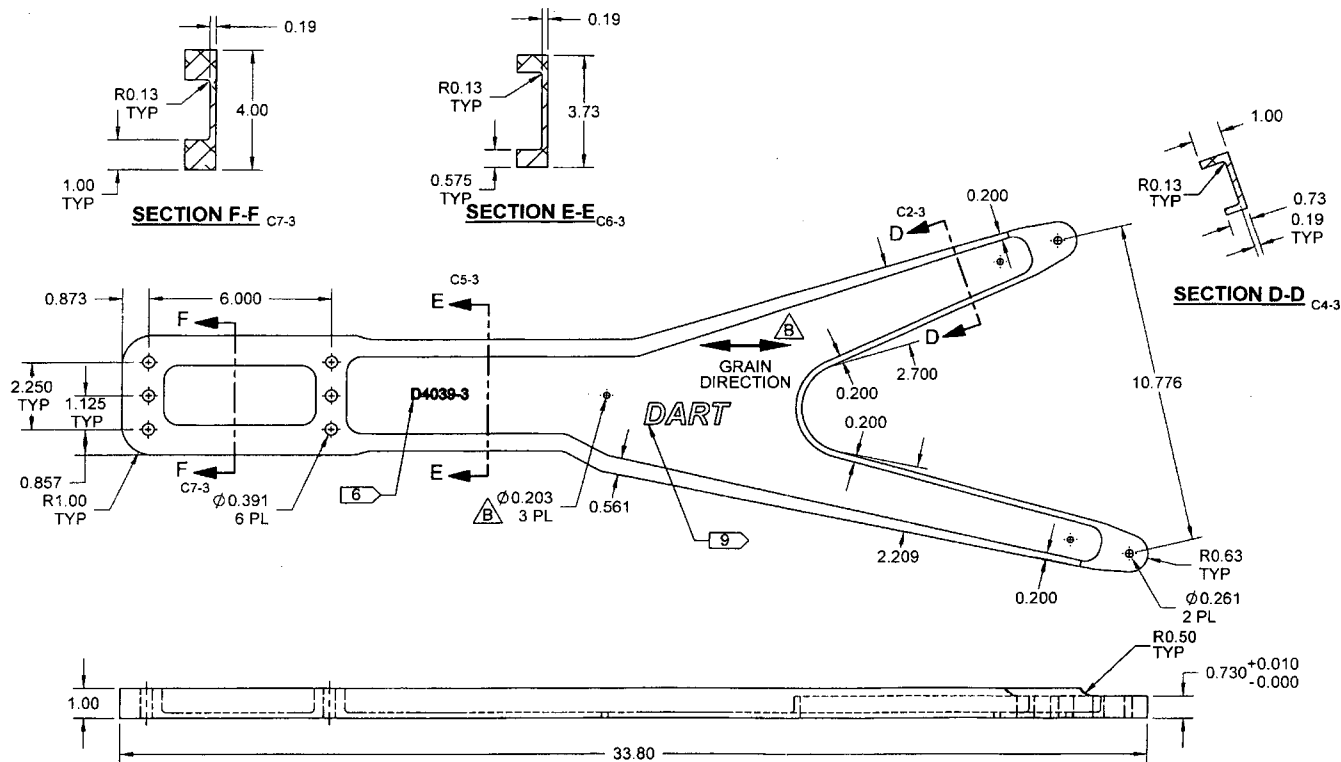


# NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 1.000 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND BATCH NUMBER IN THIS AREA TO MAX  
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010
- 7) WEIGHT: 6.64 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-1\_REV.B.SLDPRT"
- 9) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

**RELEASED**  
2010-09-27

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4039</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	NTS
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- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND BATCH NUMBER IN THIS AREA TO MAX  
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010
- 7) WEIGHT: 6.23 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-3 REV.B.SLDPRT"
- 9) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4039</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	NTS
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2010-09-23